

**Work Order ID 58866**

Wednesday, May 19, 2010 3:27:27 PM



Page 1

Item ID: D412-706-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Fuel Purge Canister

Start Date: 5/19/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 5/26/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: 14Date: 10-5-19

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

DSI 9494

A

IIN-D412-706

A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D412-706-011 CHG003

8/10/20

HGA BG 10/05/20 Pto →

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

P/10/20 ②

# Dart Aerospace Ltd

W/O: 58866		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10/15/28	#110	Perm. Change Part missing from Pick list. ADD Parts to list - A1924-8D B <u>114544</u> x1 per kit 5x2 - A1938-6D B <u>101925</u> x1 per kit 5x2		10/15/28			S 10/15/28	
	#110	update w/o + Bom - ADD copy of updated Bom for Reference		10.06.01			S 10/15/28	

Part No: D412-706-011 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 58866**

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Page 2

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Setup Start



Revision ID:

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Cust Item ID:

Required Date: 5/26/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

S1010528

(42)

Quality Control

130

Packaging

0.00



Packaging

Memo

0.00

Identify and pack for shipping as per PPPD412-706-011

Location: \_\_\_\_\_

PPP Rev: R

Cup 31 (2)

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

10/05/31

Quality Control

MF

10-5-31

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 58866

Parent Item: D412-706-011

Parent Item Name: Fuel Purge Canister

Comments: IPP Rev:E 04.12.03 Remove AN6289-6D; Change Qty of 924-6D KJ/JLM  
IPP Rev:F 08-05-14 revise comment in seq.17 /24 DD verified  
by:EC IPP rev G  
10.01.18 per DS19494 EC verified by:DD IPP Rev:H 10.03.23

Start Date: 5/19/2010

Required Date: 5/26/2010

Start Qty: 2.00

Required Qty: 2.00

AN3-5A

Purchased No 110 Each 957.0000

Bolt

Location Loc Qty Loc Code

ST350 957

105057 957

Purchased No 110 Each 1.0000

AN814-6D

Plug

Location Loc Qty Loc Code

ST329 1

109068 1

Purchased No 110 Each 14.0000

AN815-6D

Union-M-Flare

Location Loc Qty Loc Code

ST329 14

114348 8

114523 5

M122966 1

Purchased No 110 Each 20.0000

AN815-8D

Union-M-Flare

Location Loc Qty Loc Code

ST329 20

113749 10

114544 10

M16205

M114742

M119378 30

M112966 10

M113749

LC19028 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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IPP Rev:F 08-05-14 revise comment in seq.17 /24 DD verified  
by:EC IPP rev G  
10.01.18 per DSI9494 EC verified by:DD IPP Rev:H 10.03.23

Start Date: 5/19/2010

Required Date: 5/26/2010

Start Qty: 2.00

Required Qty: 2.00

AN832-6D Purchased No 110 Each 3.0000

UNION

Location Loc Qty Loc Code

ST333 3

107737 3

AN833-6D Purchased No 110 Each 16.0000

Elbow, Bulkhead-M-Flare

Location Loc Qty Loc Code

ST333 16

111650 16

AN833-8D Purchased No 110 Each 21.0000

ELBOW

Location Loc Qty Loc Code

ST333 21

10 M114341 10

113706 1

114544 10

AN924-6D Purchased No 110 Each 9.0000

Nut

Location Loc Qty Loc Code

ST335 9

111650 9

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Page 2

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 3

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 IPP Rev:F 08-05-14 revise comment in seq.17 /24 DD verified  
 by:EC IPP rev G  
 10.01.18 per DSI9494 EC verified by:DD IPP Rev:H 10.03.23

Start Qty: 2.00

Required Qty: 2.00

AN924-8D	Purchased	No	110	Each	21.0000	1	
NUT							
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>		
			ST335	20			
			114341	10			
			114544	10			
			ST336	1			
			113706	1			
AN960JD10	Purchased	No	110	Each	0.0000	18	
Washer							
AN960JD10L	Purchased	No	110	Each	4,017.000	4	
Washer							
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>		
			ST348	4017			
			110985	4017			
AN960JD916	Purchased	No	110	Each	22.0000	2	
WASHER							
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>		
			ST348	22			
			109174	22			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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IPP Rev:F 08-05-14 revise comment in seq.17 /24 DD verified  
by:EC IPP rev G  
10.01.18 per DSI9494 EC verified by:DD IPP Rev:H 10.03.23

Start Date: 5/19/2010

Required Date: 5/26/2010

Start Qty: 2.00

Required Qty: 2.00

D2001-4 Manufactured No 110 Each 11.0000

S2  
Valve Assembly (1/4")

Location	Loc Qty	Loc Code
ST002	11	
55525	5	
56682	6	

D3262-043 Manufactured No 110 Each 4.0000

S2  
Canister Assembly

Location	Loc Qty	Loc Code
ST144	4	
58295	4	

D3264-1 Manufactured No 110 Each 11.0000

S2  
Bracket

Location	Loc Qty	Loc Code
ST144	11	
55733	11	

D3297-1-0098 Manufactured No 110 Each 4.0000

S2  
HOSE ASS'Y

Location	Loc Qty	Loc Code
ST194	4	
47500	4	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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IPP Rev:F 08-05-14 revise comment in seq.17 /24 DD verified  
by:EC IPP rev G  
10.01.18 per DSI9494 EC verified by:DD IPP Rev:H 10.03.23

Start Date: 5/19/2010

Required Date: 5/26/2010

Start Qty: 2.00

Required Qty: 2.00

D3297-3-0085

Manufactured No

110

Each

4.0000

HOSE ASS'Y

Location

Loc Qty

Loc Code

ST194

4

47501

4

110

Each

4.0000

D3297-3-0210

Manufactured No

HOSE ASS'Y

Location

Loc Qty

Loc Code

ST194

4

47502

4

110

Each

17.0000

D3298-005

Manufactured No

Tube Assembly

Location

Loc Qty

Loc Code

ST195

17

47505

4

48509

7

55527

6

110

Each

6.0000

D3298-007

Manufactured No

Tube Assembly

Location

Loc Qty

Loc Code

ST195

6

55529

6

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 58866

Parent Item: D412-706-011

Parent Item Name: Fuel Purge Canister

Comments: IPP Rev:E 04.12.03 Remove AN6289-6D; Change Qty of 924-6D KJ/JLM  
 IPP Rev:F 08-05-14 revise comment in seq.17/24 DD verified  
 by:EC IPP rev G  
 10.01.18 per DS19494 EC verified by:DD IPP Rev:H 10.03.23

Start Date: 5/19/2010

Required Date: 5/26/2010

Start Qty: 2.00

Required Qty: 2.00

D3299-3 Manufactured No 110 Each 24.0000



Fitting

Location Loc Qty Loc Code

ST050 24  
 42171 18  
 55530 6

92171

D3299-5 Manufactured No 110 Each 19.0000



Fitting

Location Loc Qty Loc Code

ST050 19  
 43657 13  
 55531 6

43657

D3299-7 Manufactured No 110 Each 17.0000



Fitting

Location Loc Qty Loc Code

ST050 17  
 57411 17

57411

D3301-1 Manufactured No 110 Each 27.0000



Placard

Location Loc Qty Loc Code

ST050 27  
 47422 3  
 56601 12  
 56685 12

47422

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Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 58866



Parent Item: D412-706-011



Parent Item Name: Fuel Purge Canister

Start Date: 5/19/2010

Required Date: 5/26/2010

Comments: IPP Rev:E 04.12.03 Remove AN6289-6D; Change Qty of 924-6D□KJ/JLM  
IPP Rev:F 08-05-14 revise comment in seq.17 /24 DD verified  
by:EC IPP rev G  
10.01.18 per DSI9494 EC verified by:DD IPP Rev:H 10.03.23

Start Qty: 2.00

Required Qty: 2.00

D3301-3 Manufactured No 110 Each 13.0000



Placard



Location Loc Qty Loc Code

ST050 13

47301 3

47423 10

D3302-1 Manufactured No 110 Each 7.0000



Doubler



Location Loc Qty Loc Code

ST143 7

47424 4

54577 3

D3302-3 Manufactured No 110 Each 15.0000



Doubler



Location Loc Qty Loc Code

ST142 15

54578 15

D3329-1 Manufactured No 110 Each 14.0000



Bushing



Location Loc Qty Loc Code

ST051 14

34218 14

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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by:EC IPP rev G  
10.01.18 per DS19494 EC verified by:DD IPP Rev:H 10.03.23

Start Date: 5/19/2010

Required Date: 5/26/2010

Start Qty: 2.00

Required Qty: 2.00

D4054-001

Manufactured No

110

Each

3.0000

Tube Assembly

Location

Loc Qty

Loc Code

ST193

3

57412

3

Manufactured No

110

Each

3.0000

D4054-003

Tube Assembly

Location

Loc Qty

Loc Code

ST193

3

57413

3

Manufactured No

110

Each

11.0000

D4054-009

Tube Assembly

Location

Loc Qty

Loc Code

ST109

3

57414

3

ST110

6

ST193

8

58157

8

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by:EC IPP rev G  
10.01.18 per DSI9494 EC verified by:DD IPP Rev:H 10.03.23

Start Date: 5/19/2010

Required Date: 5/26/2010

Start Qty: 2.00

Required Qty: 2.00

MS21042L3

Purchased

No

110

Each

1,896.000

4

Nut

Location

Loc Qty

Loc Code

ST300

1896

113537

20

113644

376

114523

1000

114718

500

MS21919-WDG9

Purchased

No

110

Each

52.0000

2

Clamp

Location

Loc Qty

Loc Code

ST307

52

109174

2

111578

50

MS21920-42

Purchased

No

110

Each

10.0000

2

CLAMP(per MIL-DTL-8783C)

Location

Loc Qty

Loc Code

ST451

10

114113

10

MS29512-06

Purchased

No

110

Each

23.0000

8

O-RING

Location

Loc Qty

Loc Code

ST294

23

113691

23

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W/O:		WORK ORDER CHANGES					
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by:EC IPP rev G  
10.01.18 per DSI9494 EC verified by:DD IPP Rev:H 10.03.23

Start Date: 5/19/2010

Required Date: 5/26/2010

Start Qty: 2.00

Required Qty: 2.00

MS29512-08

Purchased No

110

Each

32.0000



O-RING



2

Location

Loc Qty

Loc Code

ST294

32

113706

32

MS35489-11

Purchased

No

110

Each

26.0000



GROMMET



1

Location

Loc Qty

Loc Code

ST295

26

109166

26

m113706

✓

PC 10/5/20 (2)

109166

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D412-706 REV. A AND ICA-D412-706 REV. 0

REF TCCA STC: SH04-54

REF FAA STC: SR02055NY

REF EASA STC: EASA.IM.R.S.01180

**REFERENCE ONLY**

## DESCRIPTION:

AT CHG 002, THE D412-706-011 FUEL PURGE CANISTER INSTALLATION HAS BEEN MODIFIED WITH LARGER VENT LINES TO ELIMINATE BACK PRESSURE THAT MAY OCCUR WHEN STARTING THE SECOND ENGINE IF THE CANISTER HAS NOT BEEN PROPERLY DRAINED. THE BACK PRESSURE IS EVIDENCED BY AN ONGOING VAPOR DISCHARGE FROM THE CANISTER VENT AT LOW TO MEDIUM RPM WHILE STARTING THE 2nd ENGINE. THE UPDATED PARTS LIST IS SHOWN BELOW:




IS

QTY -011	PART NUMBER	DESCRIPTION
X	D412-706-011	FUEL PURGE CANISTER INSTALLATION (212/412)
1	D2001-4	VALVE ASSEMBLY
1	D3262-043	CANISTER ASSEMBLY (WAS D3262-041)
2	D3264-1	BRACKET
1	D3297-1-0098	HOSE ASSEMBLY
1	D3297-3-0085	HOSE ASSEMBLY
1	D3297-3-0210	HOSE ASSEMBLY
1	D4054-001	TUBE ASSEMBLY (WAS D3298-001)
1	D4054-003	TUBE ASSEMBLY (WAS D3298-003)
1	D3298-005	TUBE ASSEMBLY
1	D3298-007	TUBE ASSEMBLY
1	D4054-009	TUBE ASSEMBLY (WAS D3298-009)
1	D3299-7	FITTING (WAS 3299-1)
1	D3299-3	FITTING
1	D3299-5	FITTING
1	D3301-1	PLACARD
1	D3301-3	PLACARD
1	D3302-1	DOUBLER
1	D3302-3	DOUBLER
2	D3329-1	BUSHING
4	AN3-5A	BOLT
1	AN814-6D	PLUG
2	AN815-6D	UNION
1	AN815-8D	UNION (WAS AN815-6D)
1	AN832-6D	UNION
1	AN833-6D	ELBOW
1	AN833-8D	ELBOW (WAS AN833-6D)

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED  
BY:   
D. SHEPHERD (DE # 02)

DATE: 10.01.07  
CERT. NO.: SH04-54  
ISSUE NO.: 1

A	NEW ISSUE	RF	10.01.07
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9494	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		212/412 CANISTER UPGRADE KIT	NTS
DATE	10.01.07	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# REFERENCE ONLY

Continue from previous sheet

4	AN924-6D	NUT
1	AN924-8D	NUT (WAS AN924-6D)
1	AN938-6D	TEE
4	AN960JD10L	WASHER (OR NAS1149D0332J)
8	AN960JD10	WASHER (OR NAS1149D0363J)
2	AN960JD916	WASHER
4	MS21042L3	NUT
2	MS21919WDG9	CLAMP
2	MS21920-42	CLAMP
8	MS29512-06	O-RING (WAS MS28778-6)
2	MS29512-08	O-RING (WAS MS28778-6)
1	MS35489-11	GROMMET

FOR CUSTOMERS WHO HAVE EXPERIENCED THIS PROBLEM IN SERVICE, THE DSI 9494-011 UPGRADE KIT IS AVAILABLE TO UPGRADE THE INSTALLATION FROM CHG 001 TO CHG 002.




QTY -011	PART NUMBER	DESCRIPTION
X	DSI 9494-011	212/412 CANISTER UPGRADE KIT
1	D3262-043	CANISTER ASSEMBLY
1	D4054-001	TUBE ASSEMBLY
1	D4054-003	TUBE ASSEMBLY
1	D4054-009	TUBE ASSEMBLY
1	D3299-7	FITTING
1	AN815-8D	UNION
1	AN833-8D	ELBOW
1	AN924-8D	NUT
2	MS29512-08	O-RING

**WEIGHT AND BALANCE:**  
NO CHANGE

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED  
BY:   
D. SHEPHERD (DE # 02)

DATE: 10.01.07  
CERT. NO.: SH04-54  
ISSUE NO.: 1

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED		DRAWING NO. REV. A
MFG. APPR.	N/A	DSI 9494 SHEET 2 OF 3
APPROVED		TITLE SCALE
DE APPR.		212/412 CANISTER UPGRADE KIT NTS
DATE 10.01.07		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries